

Thursday, 5/4/2006 11:09:44 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 26928C		
Estimate Number	: 10382		
P.O. Number	: N/A	Part Number	: D30655
This Issue	: 5/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3065 REV. A2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26452C	Drawing Revision	: A2
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/15/2006
Checked & Approved By	: <u>06.05.05</u>	Qty:	120 Um: Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.1338 sf(s)/Unit Total: 136.0548 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.080" thick
(M5052H32S.080)

Batch:

m19380
m4894

061-T6 .080 thick AK
06.06.06

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: A2

Prog Rev: A2

2-Deburr if necessary

06.06.06

(120)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAW 06.06.06

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06.06.21

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

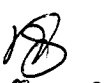

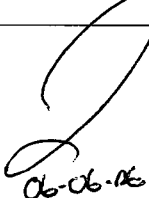
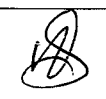


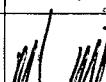
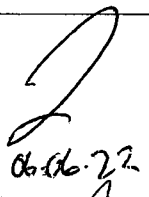

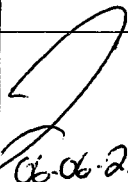
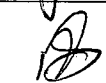
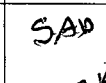
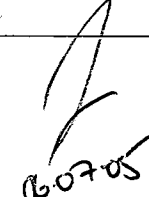
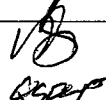
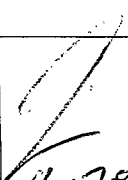
Deburr Stack

H-M 06-06-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/06
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-06-06	2.0	Qty 6 scrap due to water jet damage.		Scrap: destroy & replace	 06-06-06	 06-06-06	 06-06-06	 06-06-06
06-06-22	2.0	Qty 7 scrap due to water jet damage in: Around the holes.		Scrap: destroy	 06-06-22	 06-06-22	 06-06-22	 06-06-22
06-07-05	7.0	1 part was found in chlorine line		Part was scrap & destroy	SAD  06/07/05	 06-07-05	 06-07-05	 06-07-05

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:09:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 26928C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/07/05

112

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-06-29

(113)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/07/05

112

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/07/05

112

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/07/06

(112)

Job Completion



U 06-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

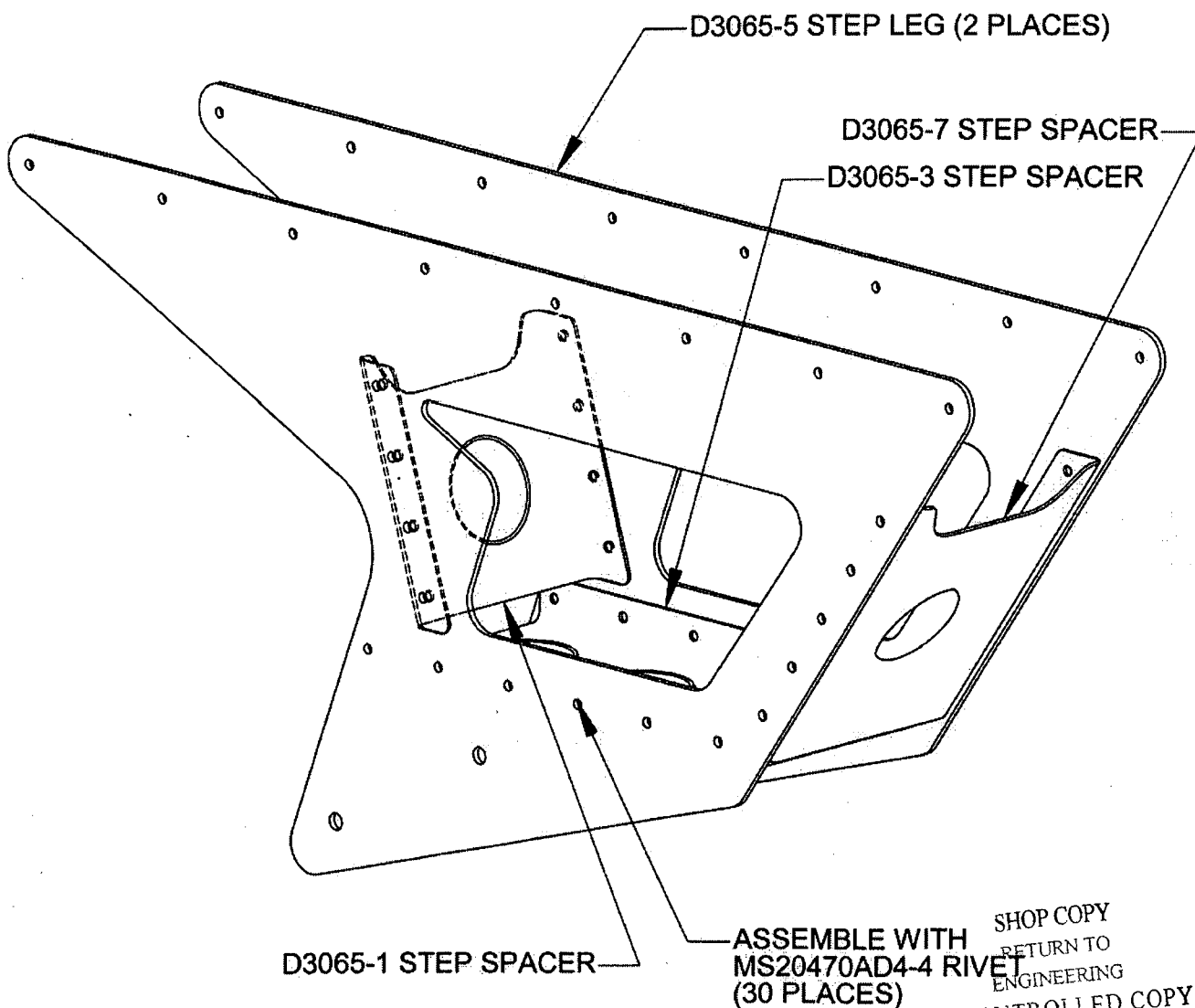
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 02.09.11		TITLE STEP LEG ASSEMBLY SCALE 1:2	
A	02.09.11	NEW ISSUE	
A1	03.02.13 <i>CP</i>	ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>	0.551 WAS 0.410	

RELEASED
02.09.20 *#*



D3065-041 STEP LEG ASSEMBLY

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NO. **26928C**

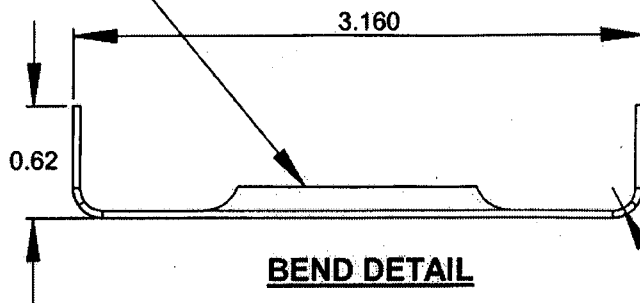
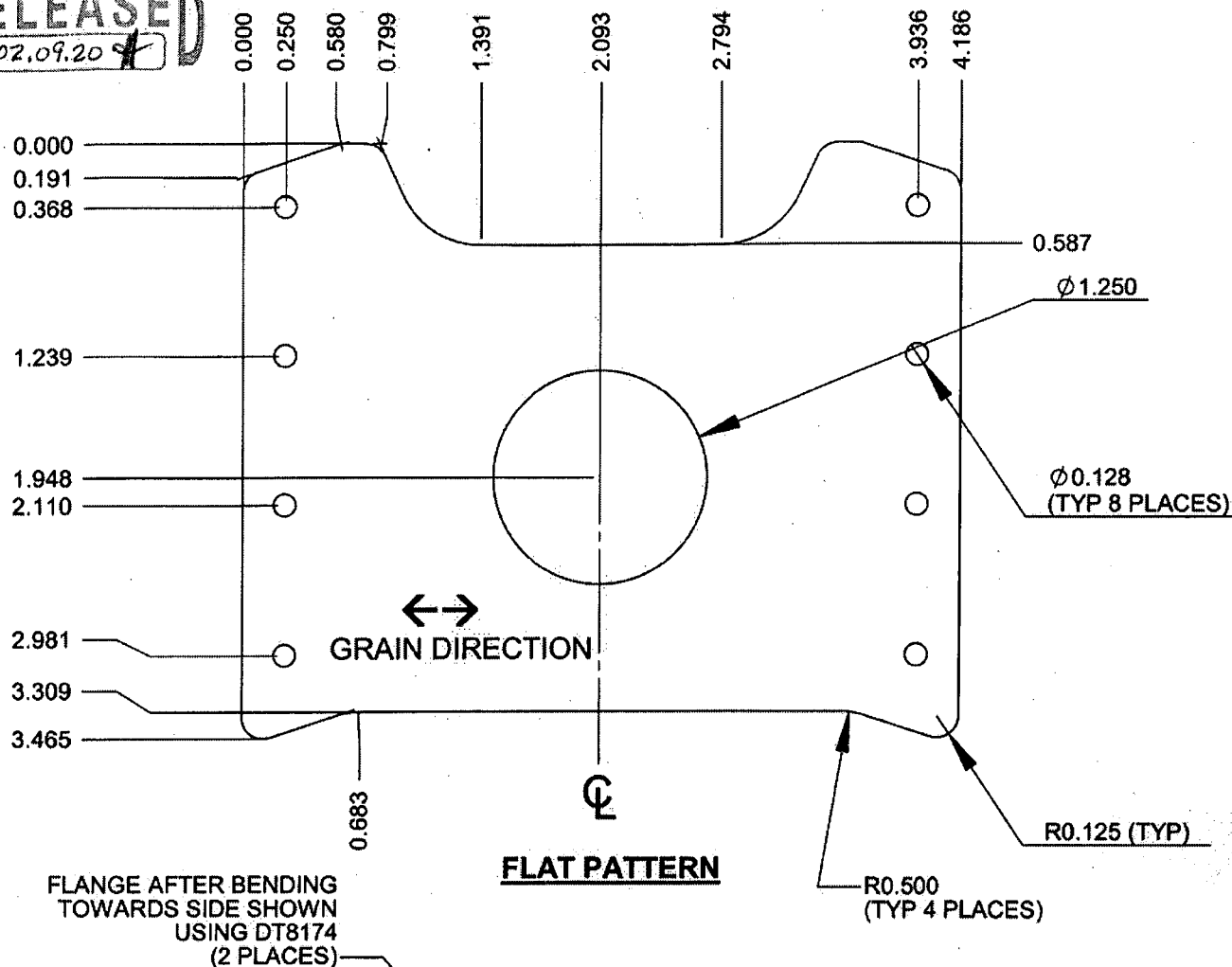
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 *[Signature]*



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 26928c

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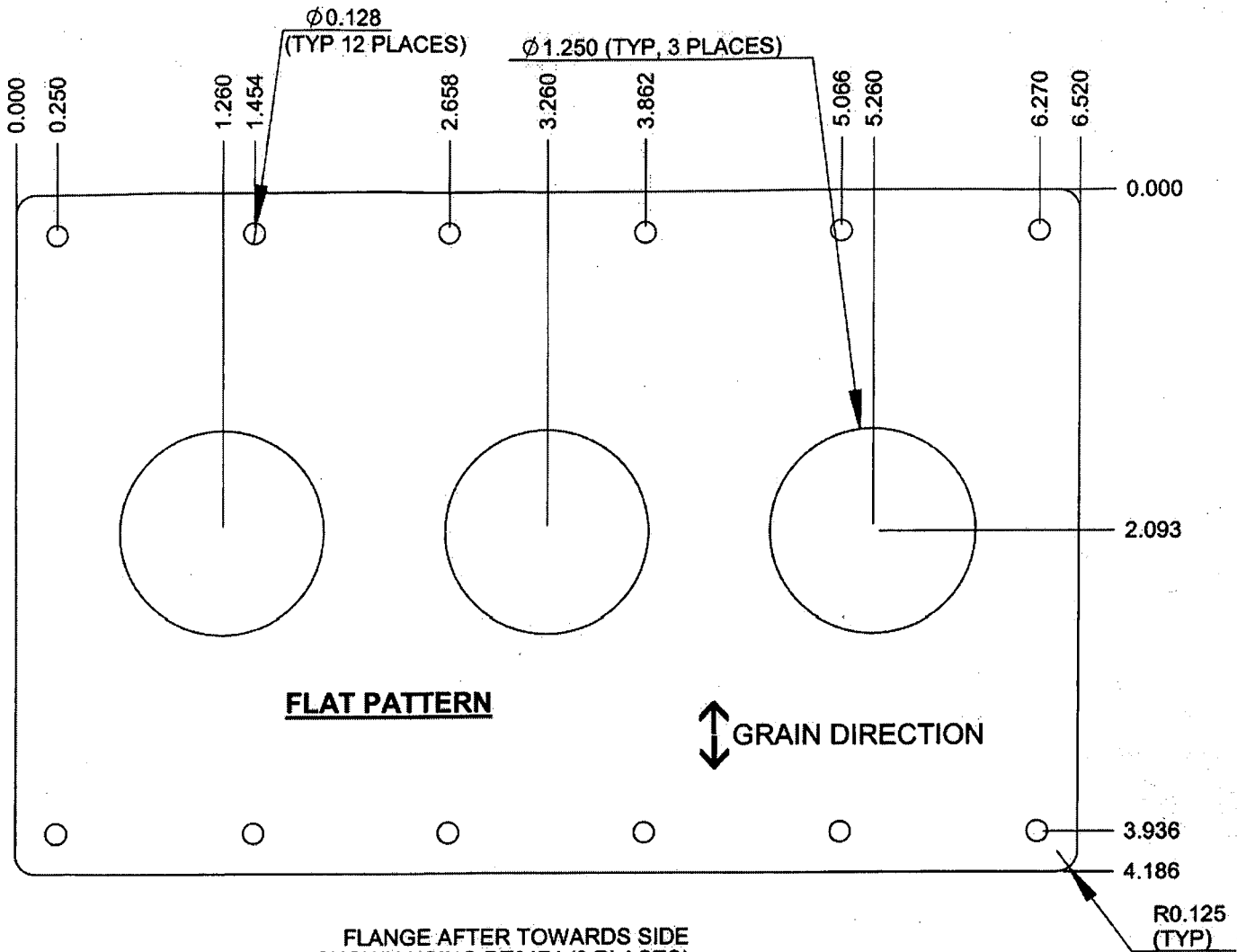
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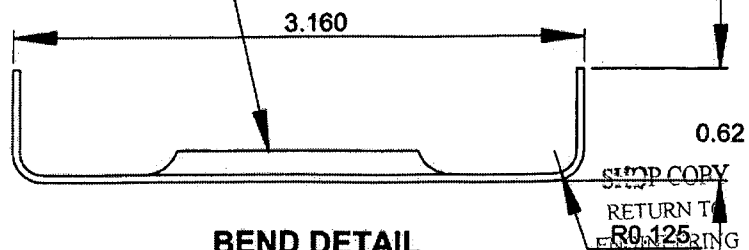
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DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

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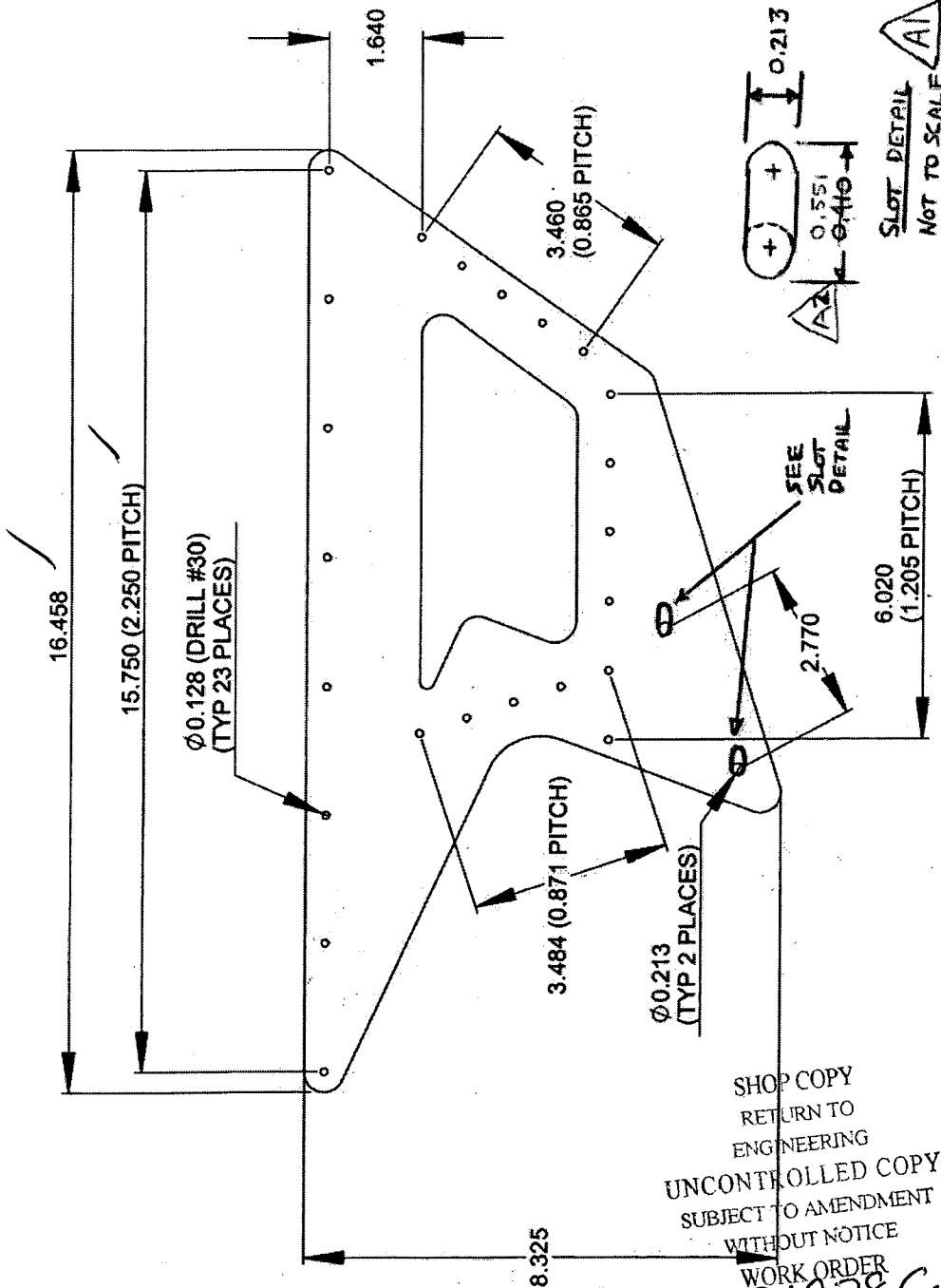
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:3

RELEASED
02.09.20



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080) OR 6061-T6
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

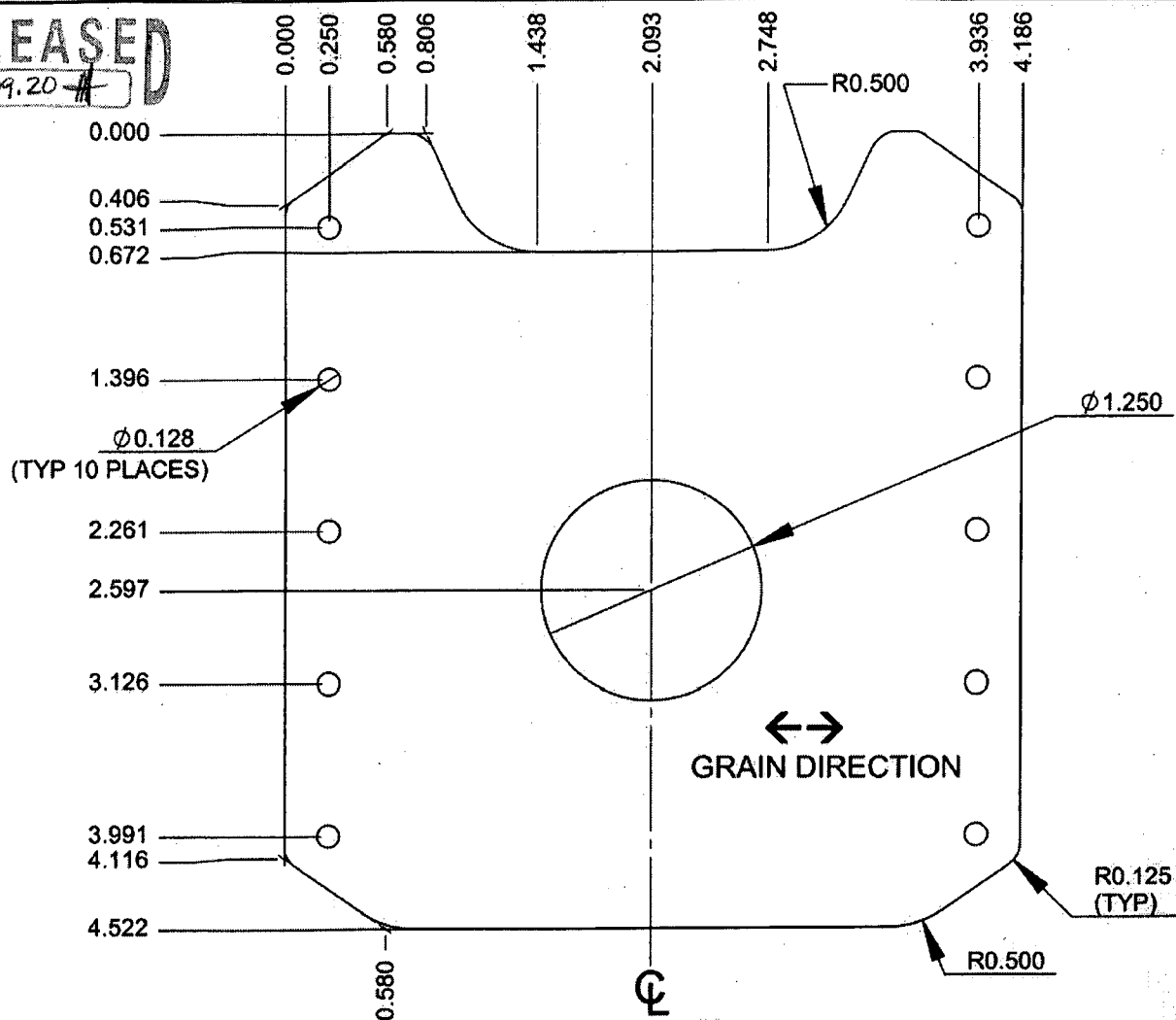
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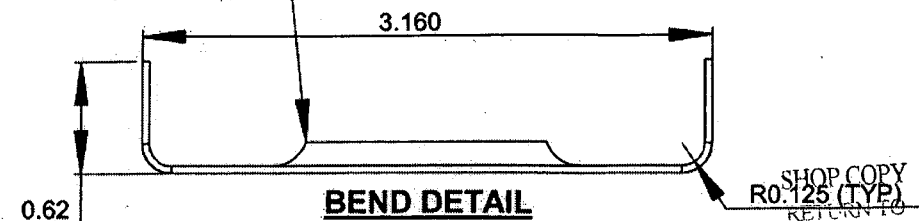
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY SCALE 1:1	

RELEASED
02.09.20



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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